

Ship July 14

Dart Aerospace Ltd.

Date: Thursday, 6/29/2006 3:52:34 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 27795	
Estimate Number : 10564	
P.O. Number : N/A	Part Number : D34433
This Issue : 6/29/2006 S.O. No. : N/A	Drawing Number : D3443 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 27530	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 7/12/2006
Checked & Approved By : <u>06 06 29 N</u>	Qty: <u>10</u> Umt <u>1</u> Each
Comment : Est Rev: A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304R1500



Batch: M19052 35"



Comment: Qty.: 0.2500 f(s)/Unit Total: 1.0000 f(s)

MS 06/07/02

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
1-TURN AS PER FOLIO FA588 & DWG D3443
FOLIO REV: AA
DWG REV: B

2-DEBURR AS REQUIRED

MS 06/07/02 12X

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/07/02 12X

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: AA & Dwg D3443 Rev: B

2-Deburr per dwg D3443

J.F. 06/07/06 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27795		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/05	4-0	- setup moved while machining.		- fix speeds and feeds of cutters. Scrap. No replace.	SA 06/07/05			
06/07/06	4	The piece moved while machining in the chuck.		Scrap, no replace.	J-F. 06/07/06			

Part No: D3443-3 PAR #: N/A Fault Category: Prod - CNE NCR: ☒ Yes ☐ No DQA: JA Date: 06.07.17

NOTE: Date & initial all entries

QA: N/C Closed: JA Date: 06.07.17

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 27795

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/07/06

10

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

[Signature]

06/07/13

10

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature]

06/07/13

10

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En. 6/07/14 x 16

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57437

[Signature]

10

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

Job Completion



U 06.07.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

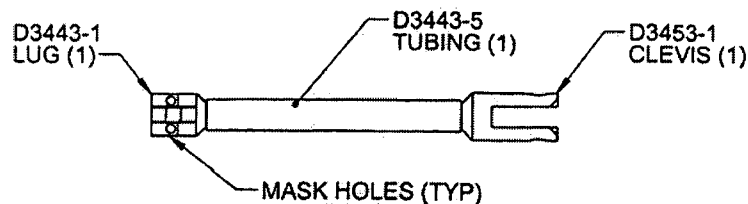
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

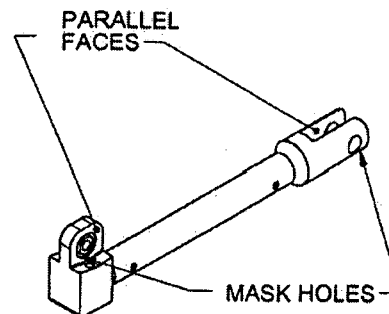
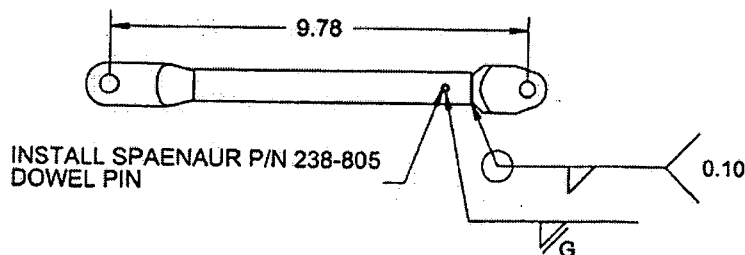
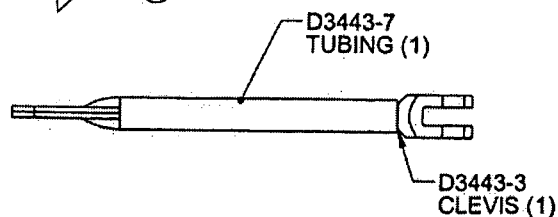
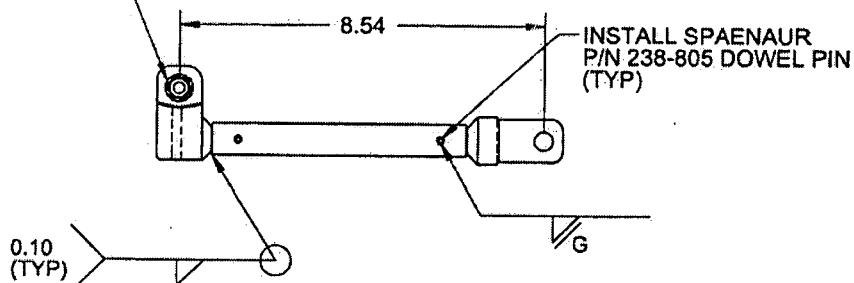
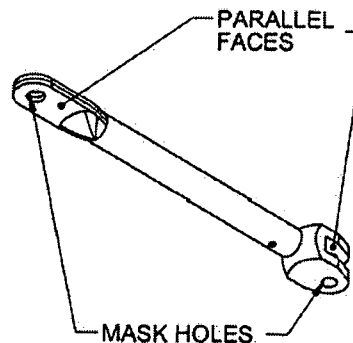
QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	

RELEASED05.12.09 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

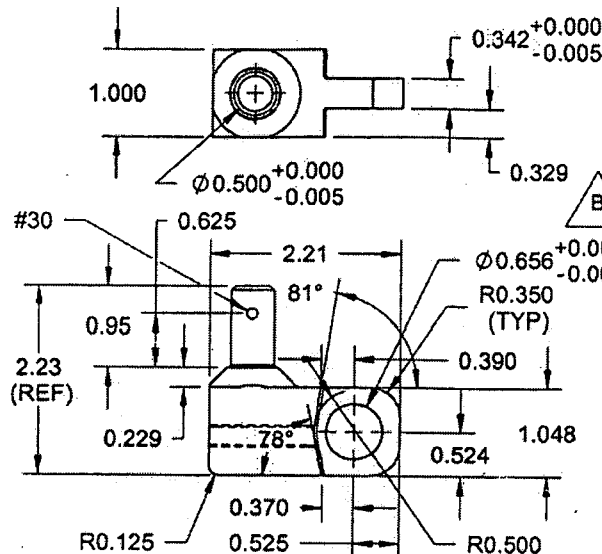
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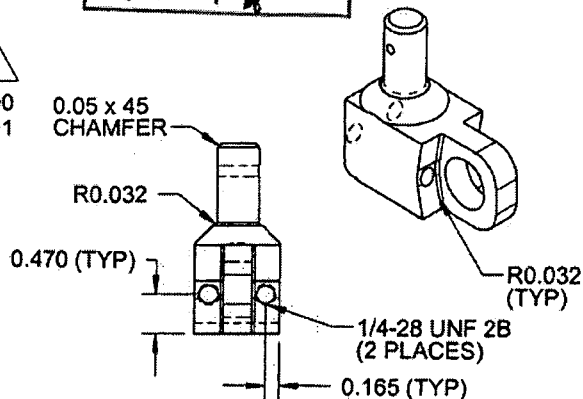
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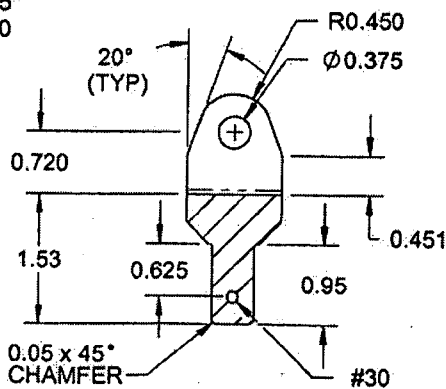
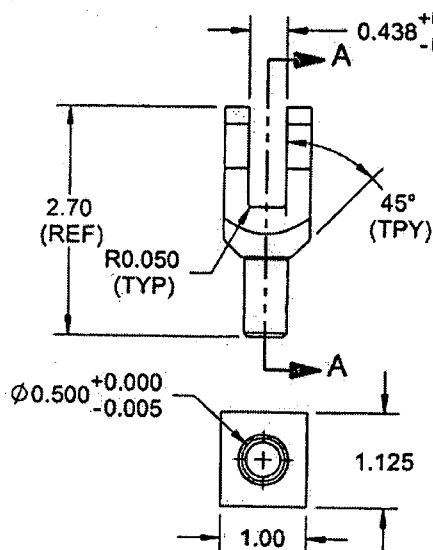
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 12		

**RELEASED**

05.12.09 #

**D3443-1 LUG****D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**SECTION A-A****D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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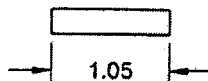
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

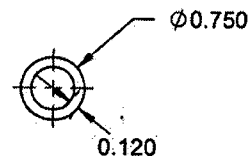
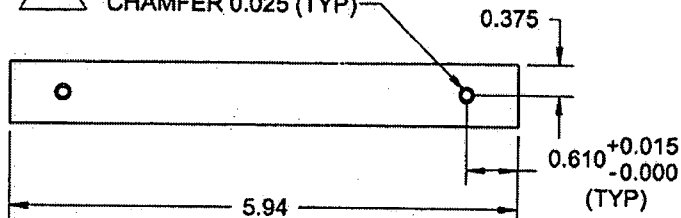
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

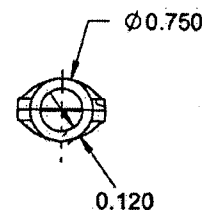
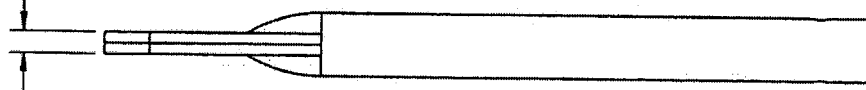


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

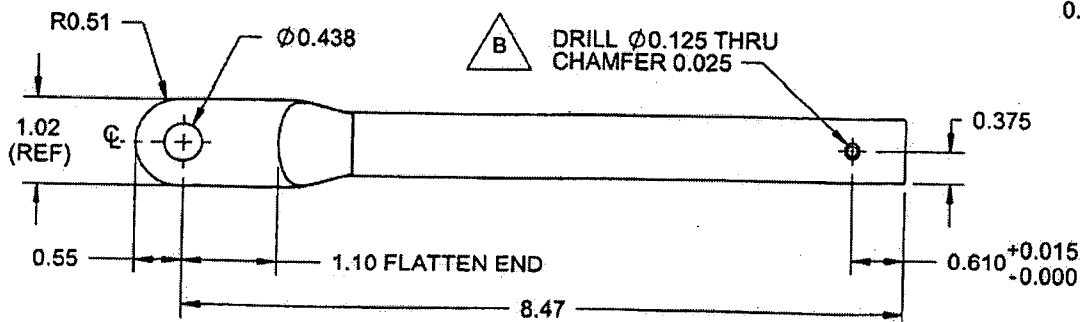


D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304/316)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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DART AEROSPACE LTD		Work Order: 27795
Description: Strut Weldment Assembly		Part Number: 3443-3
Inspection Dwg: 3443 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	+ .000 - .005	.497	✓			
.95	± .030	.951	✓			
.05X45	± .005	.05	✓			
2.70	± .030	2.722	✓			
.438	+ .005 - .000	.438	✓			
1.53	± .030	1.546	✓			
.625	± .010					Manual Milling
.95	± .030					
.720	± .010	.720	✓			
20°		20°	✓			
Ø .375	+ .006 - .001	Ø .379	✓			
.451	± .010	.450	✓			
1.00	± .030	.998	✓			
1.125	± .010	1.123	✓			
.625	± .010	.625	✓			
.129	+ .004 - .001	.129	✓			

Measured by: MB / 90	Audited by: JL / 90	Prototype Approval: -
Date: 06/07/03	Date: 06/07/03	Date: -

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	